

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017042**Date Inspected:** 08-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay # 03, Subassembly

During random in process inspection this QA inspector observed that ZPMC NDT personnel Mr. Chang Fang Jie was performing Magnetic Particle Testing (MT) on the weld joints of sub assembly. The members are identified as OBG components and the weld designations reviewed are as follows.

SA3015-001-007, 008, 019, 020

SA3016-001-005, 006, 015, 016

BAY 03, FLOOR BEAM

FCAW welding of weld joint 021 located on FB3280-001.

Welder is identified as 206623. ZPMC QC is identified as Mr. Zhang Yaxu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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FCAW welding of weld joint 031 located on FB3293-001.

Welder is identified as 217805. ZPMC QC is identified as Mr. Zhang Yaxu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

FCAW welding of weld joint 051 located on FB3293-001.

Welder is identified as 217805. ZPMC QC is identified as Mr. Zhang Yaxu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-F.

### BAY 04, BOTTOM PLATE

During random in process inspection this QA inspector observed that ZPMC personnel performing fit up by using Shielded Metal Arc Welding (SMAW) process for stiffener(RS3227D) to bottom plate (BP3080) of lift 14. Welder is

identified as 215169. ZPMC QC is identified as Mr. Shen Jian Guo. The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

FCAW welding of weld joint 281 located on BP3079-001.

Welder is identified as 050502. ZPMC QC is identified as Mr. Shen Jian Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

### EDGE PANEL EP3027

SAW welding of weld joint 109 located on EP3027-001.

Welder is identified as 050502. ZPMC QC is identified as Mr. Shen Jian Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-U3c-S-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Gaikwad,Umesh
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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